

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-018506**Date Inspected:** 07-Dec-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Xu tao**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, S.Chandrakumar was present during the times noted above for observations relative to the work being performed.

BAY#19

FCAW welding of weld is identified as 3G-006 of BK4ASD1-013 for BK004A-013. The welder is identified as 208641. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2233-ESAB.

FCAW welding of weld is identified as 4G-026 of BK4ASD1-013 for BK004A-013. The welder is identified as 208641. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-B-T-2234-ESAB.

ABF QC MT personnel performing MT on suspender bracket fillet and CJP welds, the suspender bracket is identified as SB100E, SB96W is in progress.

SMAW welding of critical weld repair weld is identified as 2F-055 of SB021-096 for SB96E. The welder is identified as 259353. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are appeared to comply with the WPS-345-SMAW-2F-Repair and B-CWR2324.

SMAW welding of critical weld repair weld is identified as 2F-003 of SB018-100 for SB100W. The welder is identified as 259353. ZPMC QC is identified as Mr. Guo xing hui. The welding variables recorded by QC are

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appeared to comply with the WPS-345-SMAW-2F-Repair and B-CWR2316.

ZPMC personnel performing End diaphragm plate with bearing plate and deck plate on bike path BK004A-013.  
Before fit-up of end diaphragm plate internal cleanliness checked with  
ZPMC QC Mr. Xu tao.

Green tag issued from step-1 to step-5 of BK004A-013 is issued after NDT carried out successfully. Green tag no -004976.

This QA inspector performed MT 15% of weld areas previously tested and accepted by ZPMC Quality Control personnel. This QA inspector generated an MT report for this date. The members are identified as OBG bike path and suspender bracket. The weld designations reviewed as follows.

SB108E – X64BC CWR buttering location.

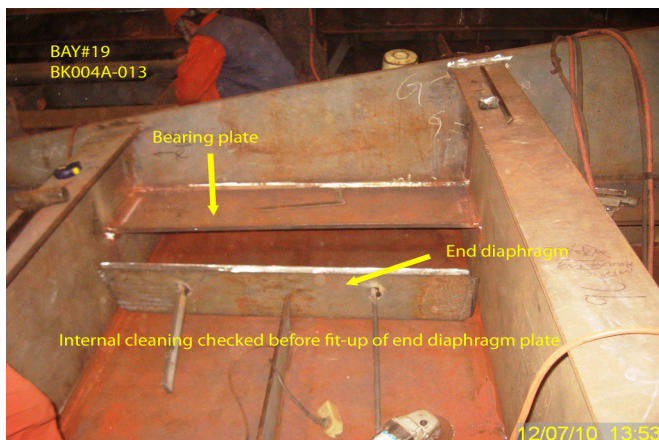
BK004A6-006-001,165,002,007.

BK004A8-008-001,130,002,007.

SB021-096-001,004,007,008,005,016,014,015,019,021,020,043,047,048,045,046,059,060,058,055.

SB018-100- 004,007.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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### Summary of Conversations:

No relevant Conversation.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang-15--0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Kumar,Chadra	Quality Assurance Inspector
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<b>Reviewed By:</b>	Patel,Hiranch	QA Reviewer
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